

Date: Wednesday, 7/25/2007 12:19:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 33733

Part Number: D2244116

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		7/10/11 3P 82 1.11 07.09.10
6.0	QC21	Comment: FINAL INSPECTION/W/O RELEASE Identify and Stock (in feet) Location: WA

Job Completion:

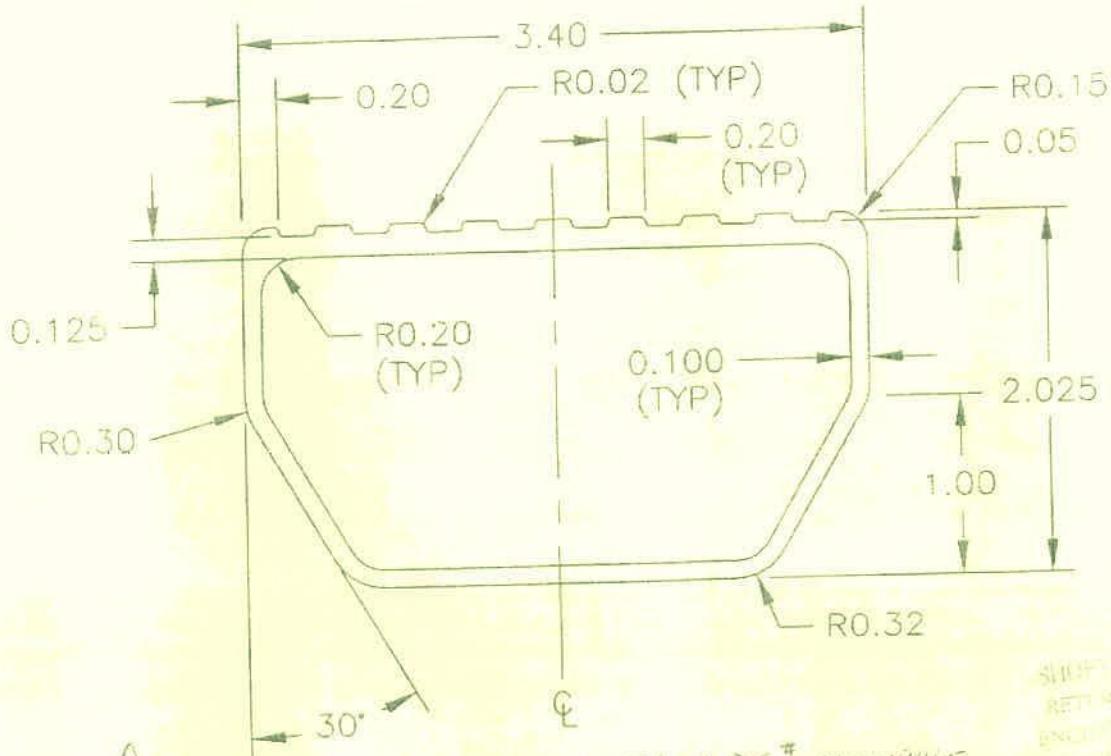


U 87.10.12



DESIGN BW	DRAWN BY <i>DP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>MM</i>	DRAWING NO. D2244	REV. D SHEET 1 OF 1 SCALE 1:1
DATE 98.11.18	TITLE STEP EXTRUSION		
A	94.07.05	NEW ISSUE	
B	94.07.11	REDESIGNED	
C	94.08.08	REDESIGNED	
D	98.11.18	REMOVED 6005A MATERIAL INCORPORATED DEO 9081	
D1	01.04.17	ADDED DIE # <i>#47</i>	

RELEASED
11-25-98 KE



MANUFACTURED USING CARBON INDALUX DIE # MH-18865

PART NUMBER D2244-XX.X
XX.X IS CUT LENGTH IN INCHES

MATERIAL: 6061-T6 (QQ-A-200/8)

SHEET 1 OF 1
REDESIGNED
UNCONTROLLED
SUBJECT TO CHANGE
WITH 24 HRS
NO. 33733

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED



INDALEX LIMITÉE
325, RUE AVRO
POINTE-CLAIRE (QUÉBEC) H9R 5W3
TÉL.: 514-697-5120 • FAX: 514-694-8310

PROFILÉS D'ALUMINIUM - ANODISATION - FABRICATION - PEINTURE ALUMINUM EXTRUSIONS - ANODIZING - FABRICATION - PAINTING

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONT

EXPÉDIÉ / SHIP TO

INDICATIONS SPECIAL
SPECIAL INSTRUCTION

7072353 1

MÊME - SAME

K6A1K7

CUSTOMER P.S.T. : *6122-5207

INDALEX G.S.T. REG NO: R13683404

Required Date

N° DU CLIENT CUST. NO.	T.P.S. G.S.T.	TAUX DE VENTE PROV. PROV. SALES TAX		N° DE COMMANDE DU CLIENT CUST. ORDER NO.		DATE DE COMMANDE ORDER DATE		NOTRE DATE DE COMM. OUR ORDER DATE		CONDITIONS TERMS
201355	XXXXXX			4253		7/07/25		7/07/25		
VENDEUR SALESMAN	EXPÉDIE PAR SHIP VIA	PAIÉ PPD.	PERC. COL.	CAD. C.O.D.	FAB. F.O.B.	EN BALLOTS BUNDLED AND TAPE		CARTONNÉ CARTONED	CARTONNÉ & INTERCALE CARTONED & INTERLEAVE	
51	NETHE CALAIS CIN THUOC	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	THAILANDE OUR FLIGHT	<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>	
ITEM ITEM #	COMMANDE ORDERED	N° DE MATRICE INDALEX DIE NO		DESCRIPTION DU CLIENT CUSTOMER DESCRIPTION				ALLIAGE ET TRÉMPAGE ALLOY AND TEMPER	LONGUEUR LENGTH	PRIX UNITAIRE UNIT PRICE
	POIDS WEIGHT	PIÈCES PIECES								
F EXTRUDE ONLY										
DUE=2007/08/10 ASAP										
1	500	86	MH 18865 D2244		6061		T6	2946		
STEP EXTRUSION										
BUNDLE= 778194✓ 778202✓ 778204✓										
<p>We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures</p> <p style="text-align: center;">9000 6700 26</p>										



325 rue Avro
Pointe-Claire QC H9R 5V3

Téléphone (514) 697-5120
Fac-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD
Adresse / Address : 270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7

commande Indalex / Indalex order # : 7072353

bon de commande / Purchase order # : 4253

de matrice / Die # : MS 18865 Description : Step Extrusion

Alliage & trempage / Alloy & temper : 6061 T6

Contrôle / Control # : 53143-1

Coulée / Cast # : 41148

	Min.requis Mi required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	41184
Contrainte élastique Yield stress (psi)	35 000	35497
% élongation dans 2" % elongation in 2"	8	12
Dureté Rockwell E (hrc) Rockwell E Hardness (hrc)	80 @ 100	90

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Al
6063	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6005A	0.68 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.24	0.48 - 0.52	0.03 Max	0.05 Max	0.03 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6351	0.7 - 1.3	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80	—	0.20 Max	0.20 Max

Nous certifions que le matériel fourni renconrre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spéclimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spéclimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre, date : 2007-01-03

Yours truly,

Mark Oliver Koklong
Technicien de la qualité

Indalex Limited

